



Dart Aerospace Ltd.
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RBE350A94-2720-00-5

Job Sheet 182998



Part No: RBE350A94-2720-00-5

Job Qty: 2 ea

Part Name: Bottom Tube Half



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/10/18

Job Tracking No:

Due Date: 9/10/18

Created By: Eric Larocque

Type: SOLD

Description:

Note: DWG RBE350A94-2720-00 Rev. 2 IPP Rev. A 18.09.05 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		9/10/18	0.00	0.00	Start Up Machining-4		EL
100	Bandsaw	2 pcs		9/10/18	0.08	0.10	Bandsaw1		EL
120	Lathe Conv	2 pcs		9/10/18	0.50	0.17	Lathe Conv-2		EL
130	QC	2 pcs		9/10/18	0.00	0.00	QC2 Machining-5		EL
131	Mill Conv	2 pcs		9/10/18	0.00	0.50	Mill Conv 2		EL
132	QC	2 pcs		9/10/18	0.00	0.00	QC2 Machining-4		EL
140	QC	2 pcs		9/10/18	0.50	0.20	QC8 Machining-5		EL 18-09-10
150	Packaging	2 pcs		9/10/18	0.00	0.00	Packaging3-2		EL
160	QC21-SA	2 Ea		9/10/18	0.00	0.00	QC21		EL 18-09-10

Part Op 120 - 1-Machine as per DWG. (Face) 2-Deburr
Descriptions: 131 - 1-Machine as per DWG. 2-Deburr
150 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1018TR2.125W.120	M1018TR2.125W.120	.2660 ft (.133 ea)	90-Start up Operation	5073661
79 72 k117	Thick wall steel Untreated Pipe			

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M1018TR2.125W.120	0	0	0

Part Specifications



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not be found.

Container No: S108825



Part: RBE350A94-2720-00-5

Job No: 182998

Serial No/Batch: S108825

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 09/10/18

Plex 9/10/18 10:31 AM dart.larocque.eric

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

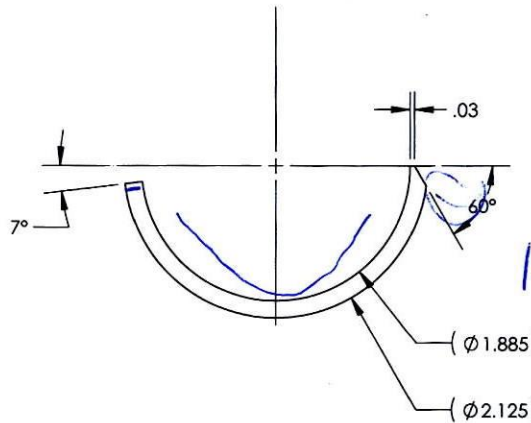
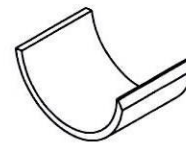
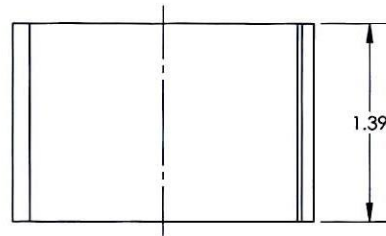
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-05 ADDED MISSING DIMS FOR R.50. DELETED Ø.236 & MADE HOLE Ø.313 ONLY.	5/22/14	DJN	RJC
2	15-0063	-5 REDESIGNED.	3/16/2015	DPD	JAG



SEPT 7/18
THIS OP/ID IS
ACCEPTABLE *MD*

1.937
0.120 wall
2.177

(-5)
BOTTOM TUBE HALF

		TITLE	
		HANDLE, ROTARY ADJUSTMENT	
DWG NO.		REV	
RBE350A94-2720-00-5		2	
MATERIAL		DRAWN BY:	
STEEL TUBE		DUERFELDT	
UNLESS OTHERWISE SPECIFIED		APPROVED	
DIMENSIONS ARE IN INCHES		REXT	
.XXX ± .010		TREAT	
.XX ± .03		FINISH	
.X ± .1		SEE -1 WELDMENT	
ANGLES ± 6°		SPEC	
1. BREAK ALL SHARP EDGES .016 x 45°		USED ON MODEL	
OR .016		AS350	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE	1:1	DATE	3/11/2015
		SHEET 4 OF 9	